

Work Order ID 70664

Monday, June 13, 2011 7:58:50 AM



Page 1

Item ID: D3404-1

Accept



Setup Start



Revision ID:

Item Name: GHW Lug

Stop



Start Date: 6/13/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 6/27/2011 Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan:

CL

Date: 11/06/13

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3404

Rev C

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank: 2.750" long

inf 11/06/16

40

N0

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS

Memo

0.00

HAAS CNC vertical machine #1

1-Machine as per Folio FA555 and Dwg D3404 Dwg Rev: Folio Rev:

☐ 2-Deburr

issue R/O to Dan's precision

machine as per dwg D3404 REV. C

CL 11/06/21 (40)

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*read + inspect for transit damage -
attached C of C to W/O.*

11/06/15 (37)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 70664

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Page 2

Item ID: D3404-1

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Revision ID:

Stop



Item Name: GHW Lug

Start Date: 6/13/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 6/27/2011 Req'd Qty: 40.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



QC

Quality Control

QC Inspect parts - second check

Memo

0.00

0.00

S u o 7 / 0 6

counted
(37)

140



Packaging

Packaging

Identify as per dwg & Stock Location: W/A 030

Memo

0.00

0.00

EL 11-7-7 (37)

150



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

11/7/11 JF
JMF
11-07-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No ~ DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

Monday, June 13, 2011 7:58:47 AM

Work Order ID: 70664



Parent Item: D3404-1



Parent Item Name: GHW Lug

Start Date: 6/13/2011

Required Date: 6/27/2011

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev:A 05.09.01 New issue KJ/JLM
IPP rev B 09.01.28 new geometry rev.C EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.750X2.500		Purchased	No			100	f	45.6530	0.2291	9.646316			
304 BAR .750 X 2.50													

Location

Loc Qty

Loc Code

MAT050

45.653

115869

10.8

116765

32.853

116808

2

9.647 on 6/16/11

D 3404-1 P

6/4/11/5 (37)

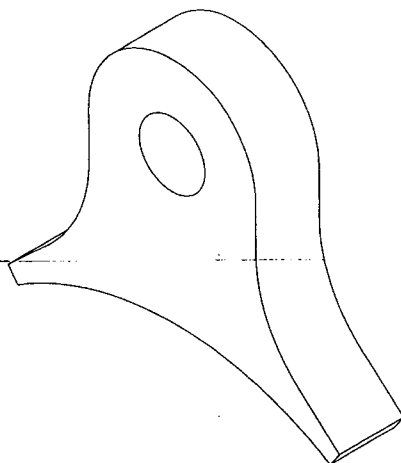
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D3404-1 GHW LUG




CL11106113

W10:70664

RELEASED
08/12/18 JWW

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.030 TO 0.060 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.34 lbs

C	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERED TO "B" SIZE BORDER. B6-2, 2.30 RAD WAS 2.13. C7-2 1.14 DIM WAS 1.20.		AJS	08.12.02
B	UPDATE M-SPEC		PH	05.06.14
A	NEW ISSUE		PH	05.03.08
REV.	DESCRIPTION		BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED		DRAWING NO.	REV. C	
MFG. APPR.		D3404	SHEET 1 OF 2	
APPROVED		TITLE	SCALE	
DE APPR.		GHW LUG	NTS	
DATE	08.12.02	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

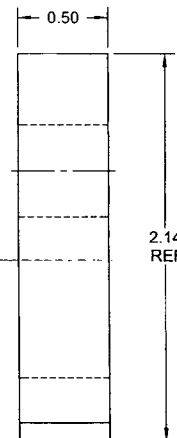
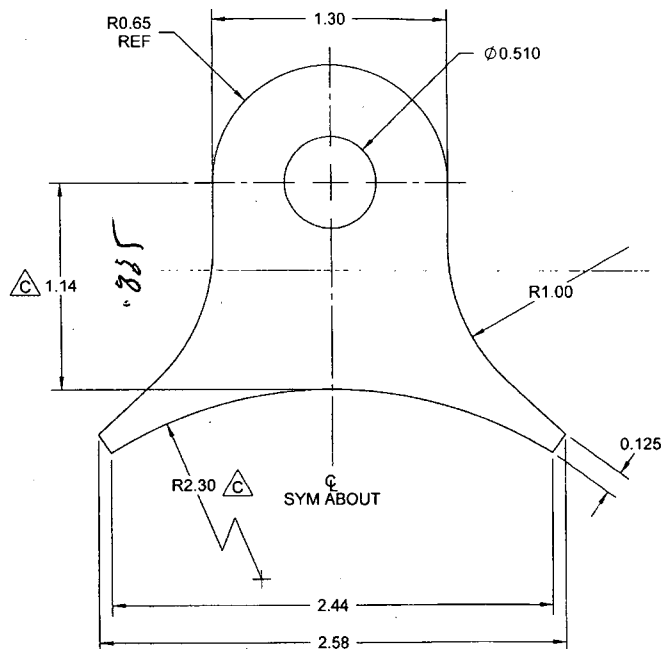
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RELEASED
08/12/18

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3404	SHEET 2 OF 2
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DAN'S PRECISION TOOLS INC.

2560 Devine Road, Vars, ON K0A3H0
Tel:(613) 835-3097 Fax:(613) 835-3760
support@dans-precision-tools.com

RE: CERTIFICATE OF COMPLIANCE

To: DART AEROSPACE LTD.
1270 Aberdeen Street
Lawkesbury ON K6A-1K7
Tel: (613) 632-5200
Fax: (613) 632-5246

- We Certify that the part listed below meets the intent of the Purchase Order, and all applicable drawings and specifications.

Date : 04-Jul-11
Purchase Order : PO14324
Packing Slip : 10538
Part Number : D3404-1revC
Quantity : 37

81107/06

Per: _____

For Dan's Precision Tools Inc.

DAN'S PRECISION TOOLS INC.

Customer: DART AEROSPACE

P.O.: PO14324

W/O: _____

Part #: D3404-1 rev C

GHW Lug

Qty: ~~4~~ 37

1

of

1